

# Work Order ID 62186

Monday, September 20, 2010 3:27:33 PM



Page 1

Item ID: D3440-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Contoured Male Eye (Supersedes B67-43001-215)

Start Date: 9/21/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *mc* Date: *10-9-30* Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3440	Rev A
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100		0.00							
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BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.00" x 2.00" x 2.200" long

*mt 10/10/01*

*4 0*

110		0.00							
-----	--	------	--	--	--	--	--	--	--



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA554 and Dwg D3440□Dwg Rev: *A* □Identify as  
D3440-15□Folio Rev: *A* □Deburr

*M.A 10/10/04*

*.4 0*

120		0.00							
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QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*M.A 10/10/04*

*4 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3440-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Contoured Male Eye (Supersedes B67-43001-215)

Start Date: 9/21/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

2L 10/10/05



QC

Memo

0.00

Quality Control

4

140

Identify as per dwg & Stock Location: 441

0.00



Packaging

Memo

0.00

Packaging

10/10/05 4

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05  
MF  
10-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 20, 2010 3:27:32 PM

Page 1

Work Order ID: 62186



Parent Item: D3440-15



Parent Item Name: Contoured Male Eye (Supersedes B67-43001-215)

Start Date: 9/21/2010

Required Date: 10/11/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.08.31 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	35.6620	0.1833	0.771789			



6061-T6 Bar 1.00 x 2.00

Location

Loc Qty

Loc Code

MAT

33.432

112567

0

115045

33.432

MAT03

2.23

112567

2.23

7777 on 10/10/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 62186
Description: Contoured Male eye		Part Number: D3440-15
Inspection Dwg: D3440 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R 0.13	+/- .030	R 0.130	✓		Rad Gage	ref.
1.55	+/- .030	1.549	✓		Vern	GA-01
1.014	+/- .010	1.012	✓		Height Gage	31006
40°	+/- 1/2°	40°	✓		Angle Meter	CNL-03
R 0.38	+/- .030	R 0.380	✓		Rad Gage	ref.
Ø 0.313	+0.006/-0.001	Ø 0.315	✓		Vern	GA-01
R 0.13	+/- .030	R 0.130	✓		Rad Gage	ref.
0.625	+/- .010	0.625	✓		Height Gage	31006
0.550	+/- .010	0.548	✓		Vern	GA-01
2.03	+/- .030	2.030	✓		"	"
0.250	+/- .010	0.249	✓		"	"
0.125	+/- .010	0.124	✓		"	"
R 0.13	+/- .030	R 0.130	✓		Rad Gage	ref.
1.00	+/- .030	0.999	✓		Vern	GA-01

Measured by: <u>B.A</u>	Audited by: <u>JL</u>	Preliminary Approval: <u> </u>
Date: <u>10/10/04</u>	Date: <u>10/10/05</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

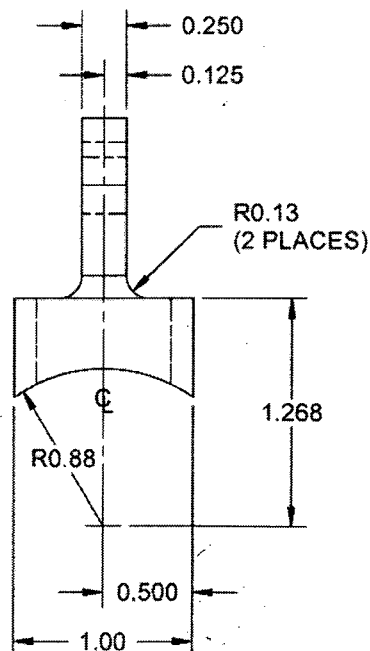
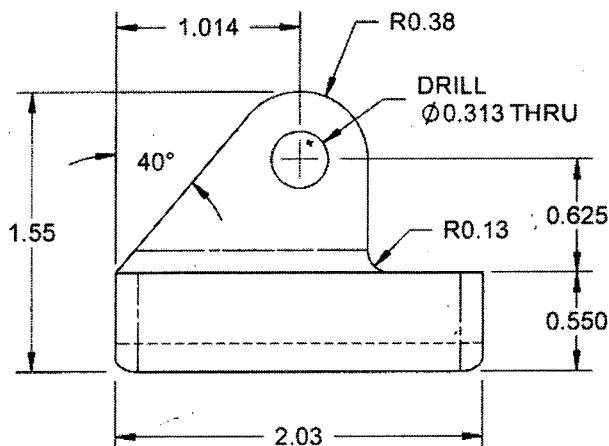
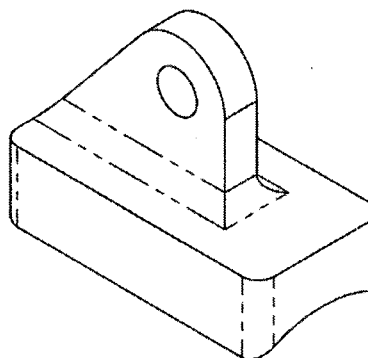
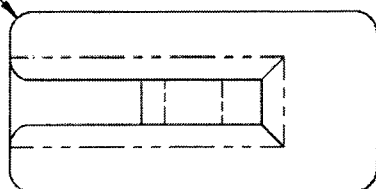
*10.04.15*



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b>	REV. A SHEET 7 OF 7
DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

RELEASED  
*[Signature]*  
05/08/18

R0.13  
(4 PLACES)



**D3440-15 CONTOURED MALE EYE**  
**SUPERSEDES PREMIER P/N B67-43001-215**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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